

Date: Thursday, 19/03/2009 4:30:45 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STA 155 BRACKET
Job Number : 46612	
Estimate Number : 11039	
P.O. Number :	Part Number : D28041
This Issue : 19/03/2009 S.O. No. :	Drawing Number : D2804 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 44475	Material :
Written By :	Due Date : 31/03/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUL 09-03-19</u>	
Comment : Est. A00.11.06 New Issue EC	
Est. B06.05.30 Blanks on wjetEC	
Est Rev:C As per Rev C 06-11-09 JLM	
Est Rev:D Removed Tumbling 08-09-09 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X12000	6061-T6 Bar .500 x 12.00
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out of MAT

Comment: Qty.: 0.7875 f(s)/Unit Total: 7.8750 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: 109253 18 9-4-4

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Template DT8534

Dwg Rev: CProg Rev: C

18 9-4-4

(4)

2-Deburr if necessary

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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(4)

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

N.A

09/04/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(4)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A

09/04/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 4:30:45 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 46612

Part Number: D28041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 09/04/13

(4)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 09/04/13

(4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 148

9/4/14

(12)

SB

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



6 09.04.14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46612
Description: Bracket		Part Number: D2804-1
Inspection Dwg: D2804	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

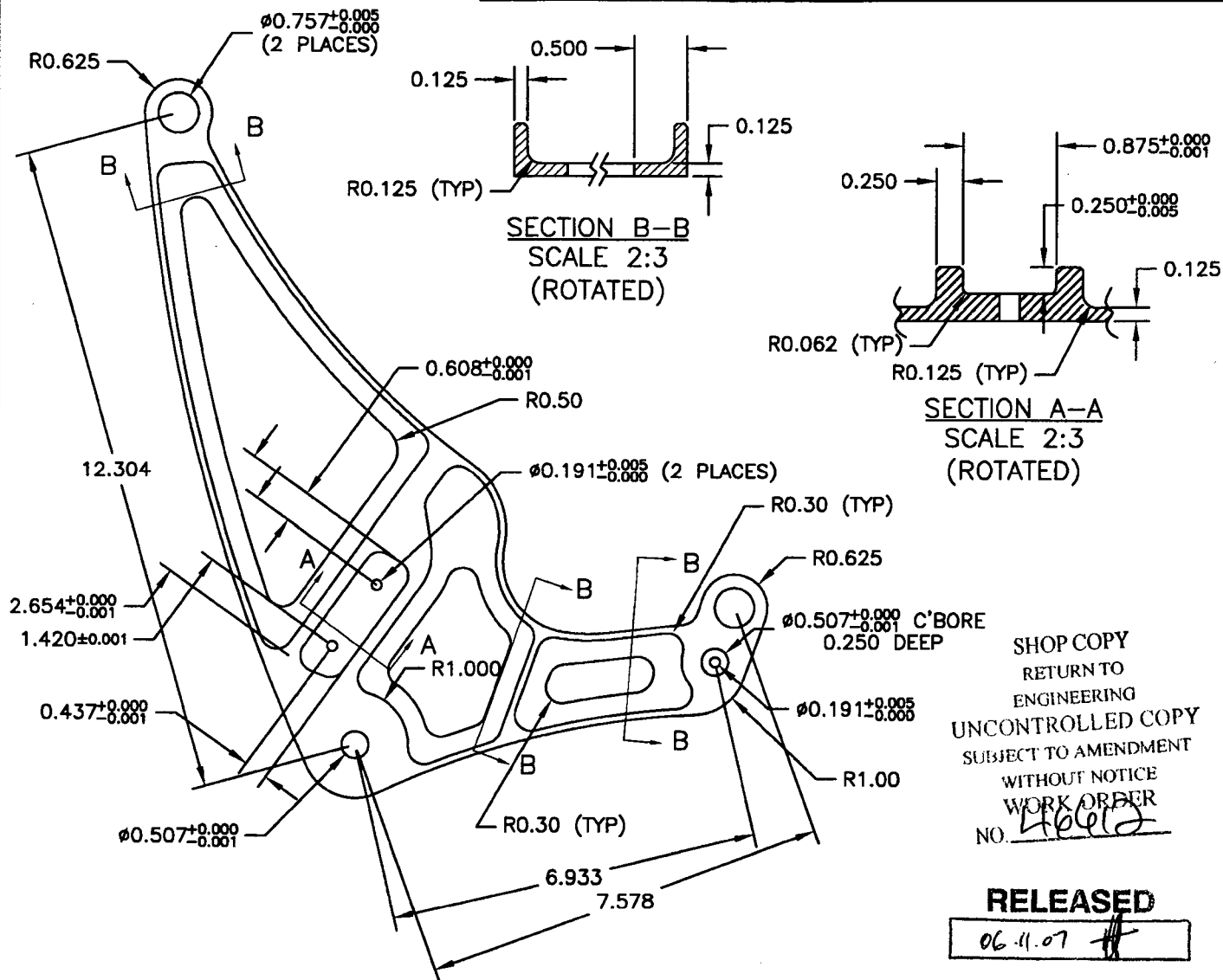
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø0.758	✓			
Ø0.191	+0.005/-0.001	Ø0.193	✓			
1.420	+/-0.001	1.420	✓			
Ø0.507	+0.000/-0.001	Ø0.5065	✓			
0.250 deep	+/-0.010	0.251	✓			
Ø0.507	+0.000/-0.001	Ø0.5065	✓			
Ø0.191	+0.005/-0.000	Ø0.193	✓			
6.933	+/-0.010	6.933	✓			
7.578	+/-0.010	7.578	✓			
12.304	+/-0.010	12.304	✓			
0.125	+/-0.010	0.127	✓			
0.500	+/-0.010	0.503	✓			
0.125	+/-0.010	0.126	✓			
0.250	+/-0.010	0.251	✓			
0.875	+0.000/-0.001	0.8750	✓			
0.250	+0.000/-0.005	0.247	✓			

Measured by: H.A	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09/04/10	Date: 09/04/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.06.05	Removed dimensions 12.625, 0.608, 0.437, 2.654	KJ/EC	
C	06.11.10	Revised per drawing revision C	KJ/JLM	
D	09.03.10	Tolerance revised for Ø0.757	KJ/DD [Signature]	[Signature]

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

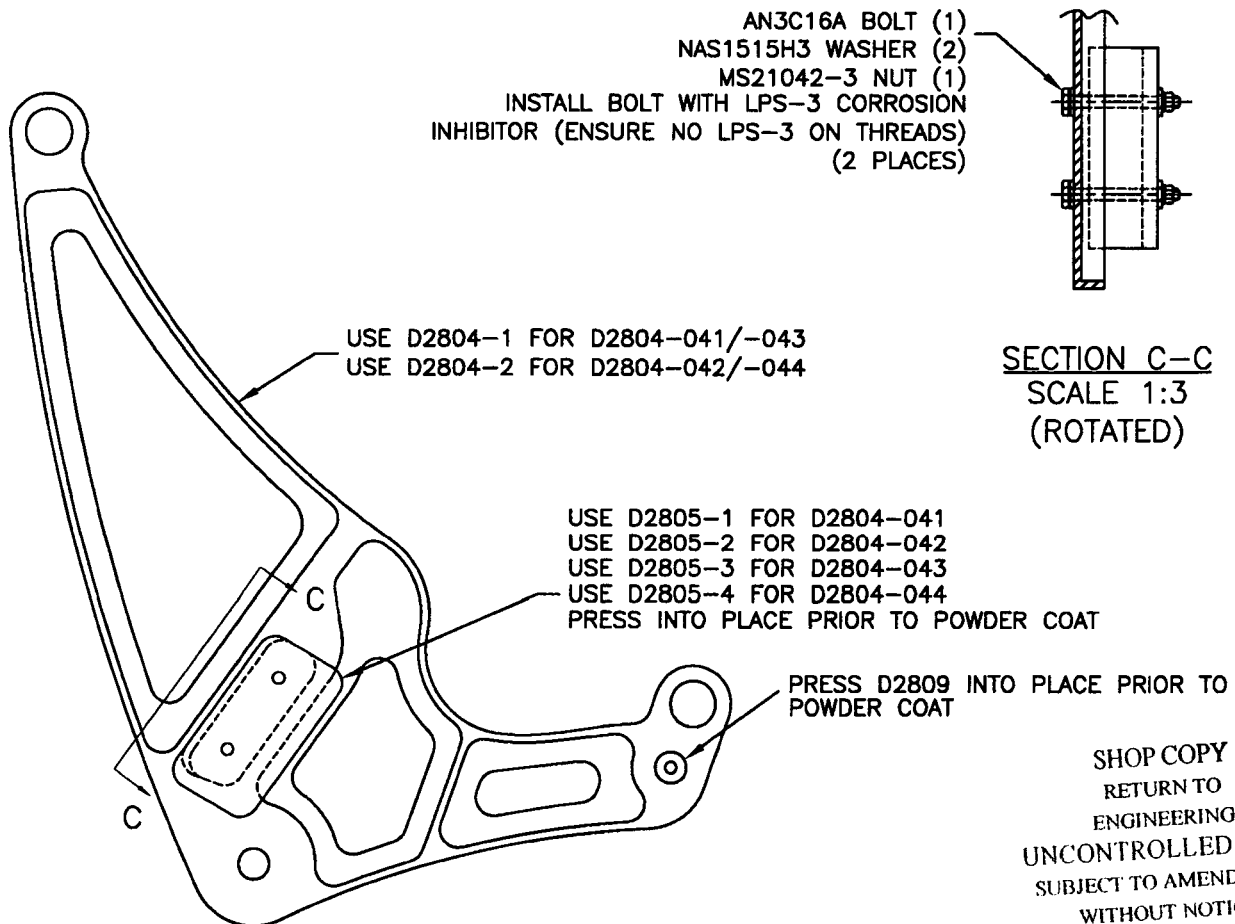
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 46012

RELEASED

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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